

# Xiamen Rizheng Industry Co.,Ltd

## Bottle Stopper Assembly Instruction

### Required accessories

- 11/32" Drill Bit
- 1/2" x 1 1/2" x 2" Blank
- 3/8"-16 TPI Drill Tap
- Stopper Mandrel
- Glue (Flexible CA or Epoxy)
- Drill Chuck
- Sandpaper/Finish
- Drill or Drill Press
- Eye and Ear Protection



### Preparing and Turning the Blank

• Your blanks should be a minimum of 1 1/4" square and 1" long. Make sure the ends are squared to the sides of the blank.

• Mark the center of each end of the blank and drill a 11/32" diameter hole about 5/8" deep in the end of the blank. Make sure the drill bit is properly positioned at 90 degrees to the end of the blank prior to drilling so that the blank seats flat against the mandrel face. Hint: Wrap masking tape around the drill bit to act as a depth gauge.

• Clamp the blank securely in a bench vise. Using a 3/8"- 16 tpi drill tap in a variable speed drill, tap the hole in the blank. Go slowly

• Mount the stopper mandrel in a drill chuck mounted in the headstock of the lathe. Screw the blank onto the threaded portion of the mandrel until it seats firmly. Secure a revolving center against the opposite end of the blank for support while turning.

• Turn the blank to your chosen profile with the revolving center supporting the work piece. Sand and finish the stopper. Slide the tailstock out of the way to sand and finish the end of the blank. Remove the revolving center and gently turn away the nub left by the revolving center. Sand and finish.

### Assembly

- Remove the finished stopper from the mandrel.
- Spread glue over the extended thread of the stopper. Insert and push the thread into the hole in the top to close the gap.
- When dry, the bottle stopper is ready to use.